

Date: Friday, 23/05/2008 8:25:49 AM
User: Linda Lacelle

Process Sheet

split wlo
SB 08/05/26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR ARM
Job Number : 39431 -2
Estimate Number : 10335
P.O. Number :
This Issue : 23/05/2008 S.O. No. :
Prsht Rev. : NC Part Number : D2010104
First Issue : 1/1 Type : SMALL / MED FAB Drawing Number : D2010 REV. C2
Previous Run : 39208 Drawing Revision :
Material :
Due Date : 30/05/2008 Qty: 20 Um: Each
Written By :
Checked & Approved By :
Comment : Est A 04.02.17 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W049 304 RD Tube .500 x .049W



Comment: Qty.: 1.5750 f(s)/Unit Total: 1.5750 f(s)

Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall

(M304TR0500W035) 049

Batch No: M107518

SEE ATTACHED

SB 08/05/23

20

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727

Identify as D2010-104

SB 08/05/23

20

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bend as per Dwg D2010 using bending Jig D2010-104T2

2- Deburr

FF 08-05-27

20

4.0 D2057 Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Plug

batch: B39432

FF 08-05-27

20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- flare before installing plug as per dwg D2010

2- Install D2057 plug as per Dwg D2010

FF 08-05-27

20

WIO: 39431-2

WORK ORDER CHANGES

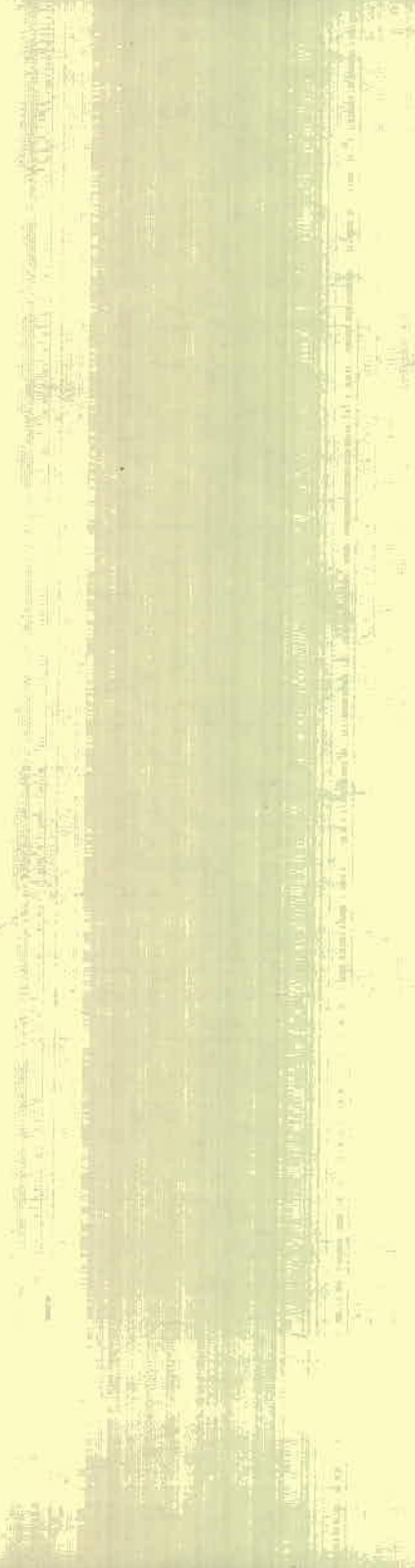
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.05.23	1	USE M304TR0500W049 Tubing instead of 0.500 x 0.035 wall PERMANENT CHANGE	RL	08.05.23	ALL	RL QSS 042 SEE ATTACHED	

 Part No: DZ010-104 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



1000000

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39431

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/27 (19)

7.0

POWDER COATING

POWDER COATING



M105642



(19x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50
320
2:20

MF 08/05/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/05/27 (19)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location 228

POSITIVE RECALL

EFFECTIVE 08/05/23 AUTH 4

RELEASED DATE 08/05/27

8/5/27 SP

(19x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



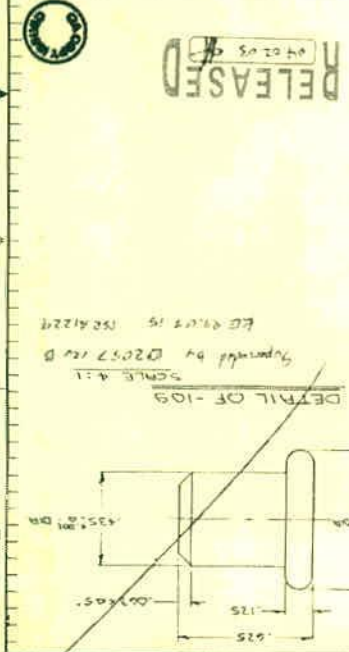
MF 08-05-28

D2010 DART AND ACCESSORIES INC. WILMINGTON, DELAWARE		DRAWING NO. D2010 SHEET NO. 1 OF 1	
PROJECT NO. 00-1-101 PROJECT NAME BRACKET DETAILS		DATE 01-05-73 BY 05042 CHECKED 0049	

ITEM NO.	DESCRIPTION	QTY	UNIT
D 2010-101	BRACKET	1	EA
D 2010-102	ARM	1	EA
D 2010-103	PLUG	1	EA
D 2010-104	SADDLE	1	EA
D 2010-105	CLAMP	1	EA
D 2010-106	POSTER	1	EA

GENERAL NOTES:

- BEND RADIUS FOR 201-T3 SHALL BE SUBSTITUTED WITH TYPICAL 300 RADIUS.
- 201-T3 SHALL BE SUBSTITUTED WITH TYPICAL 300 RADIUS.
- 201-T3 SHALL BE SUBSTITUTED WITH TYPICAL 300 RADIUS.
- 201-T3 SHALL BE SUBSTITUTED WITH TYPICAL 300 RADIUS.



Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 12, 2008 2:28 PM
To: 'Chris Provencal'; 'Mike Petsche'
Cc: 'Peter Hum'; 'Bill Beckett'
Subject: RE: R44 Mirror arm D2010-104

This deviation is acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, May 12, 2008 11:55 AM
To: 'Mike Petsche'; David Shepherd (David Shepherd)
Cc: Peter Hum; Bill Beckett
Subject: RE: R44 Mirror arm D2010-104

David,

If we make a tube with 0.049" wall, can we sign this off as a deviation on the w/o? That's the quickest way to get it out the door.

If this will be a permanent change we'll eventually need a new dwg and a new CHG #.

-Chris

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: May 12, 2008 9:36 AM
To: 'Bill Beckett'; 'Dan Stow'; 'Chris Provencal'
Cc: 'L Lacelle'; 'David Shepherd'; 'Peter Hum'
Subject: RE: R44 Mirror arm D2010-104

I assume someone's rasing a new NCR.....We had one open from the last time this haapened but we never ended up getting broken part back. Pretty sure we ended up shutting it down.

It should be directed to Peter.

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: May 12, 2008 9:27 AM
To: 'Dan Stow'; 'Mike Petsche'; 'Chris Provencal'
Cc: 'L Lacelle'; 'David Shepherd'
Subject: RE: R44 Mirror arm D2010-104

Dan - Yup, let's send him a replacement mirror arm, but I don't want to send out something that has a good chance of failing.

Chris - I suggest we make an arm with 0.049" wall vs. the 0.035" called up on the drawing, and that we sign this off as a deviation. If this is acceptable, please advise Linda ASAP.

Mike - we need to come up with a permanent solution to this issue ASAP - I believe this will apply to the R22 and MD500 as well.

Handwritten musical notation on a page with a large, dark, irregular stain on the left side. The notation is written on a series of horizontal lines, likely a musical staff, and includes various symbols and markings. The page is heavily aged and discolored, with a yellowish-brown hue. The stain on the left side is very prominent, covering a significant portion of the page and obscuring some of the text and notation. The notation itself is written in a cursive, handwritten style, typical of older musical manuscripts. The overall appearance is that of a historical document, possibly a score or a set of musical instructions.

Bill

From: Dan Stow [mailto:dstow@dartaero.com]
Sent: May 12, 2008 8:05 AM
To: Bill Beckett (Bill Beckett)
Subject: FW: R44 Mirror arm D2010-104
Importance: High

Bill,

I sent you this email last week. I am sending Russ to CHC today to pick up the skid and I need to know if you would like to send Claude a new R44 mirror arm and pick up the one that is cracked.

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.5200
Cell: 613.676.0992
dstow@dartaero.com

From: CBoule@canadianhelicopters.com [mailto:CBoule@canadianhelicopters.com]
Sent: May 8, 2008 10:04 AM
To: Dan Stow
Subject: RE: R44 Mirror arm D2010-104

Hi Dan

We have few that cracked.

I have in my hand one the cracked strut, can I shipped it to your attention , have your Engineer group to look at it for a fix.

Claude Boulé
Chief Engineer, VFR, Qc/ On/ Nb.
Tel: 450-452-3025
Fax: 450-452-2483
cboule@canadianhelicopters.com

"Dan Stow" <dstow@dartaero.com>

20/12/2007 04:15 PM

To <CBoule@canadianhelicopters.com>

cc

Subject RE: R44 Mirror arm D2010-104

Hi Claude,

16/05/2008

I have heard about this problem once before and I thought that it might be an isolated incident... I guess not. I will bring this to the attention of the design team. If you could please supply me with the Batch # of the mirror assembly and a shipping address I will send out a new arm ASAP.

Thanks for the feedback.

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.5200
Cell: 613.676.0992
dstow@dartaero.com

From: CBoule@canadianhelicopters.com [mailto:CBoule@canadianhelicopters.com]
Sent: December 20, 2007 3:53 PM
To: dstow@dartaero.com
Subject: R44 Mirror arm D2010-104

Hi

We have been replacing the D2010-104 due to crack at the mirror attachment.

It is a weak point of the design.

See attached pictures.

Were you aware about This defect?

Claude Boulé
Tel: 450-452-3025
Fax: 450-452-2483
cboule@canadianhelicopters.com

No virus found in this incoming message.
Checked by AVG.
Version: 7.5.524 / Virus Database: 269.23.16/1427 - Release Date: 11/05/2008 1:08 PM

No virus found in this outgoing message.
Checked by AVG.
Version: 7.5.524 / Virus Database: 269.23.16/1427 - Release Date: 11/05/2008 1:08 PM

16/05/2008

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No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.16/1428 - Release Date: 5/12/2008 7:44 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.16/1428 - Release Date: 5/12/2008 7:44 AM

